

Wednesday, 1/23/2008 11:39:00 AM
Kim Johnston

Process Sheet

Job No. : CU-DAR001 Dart Helicopters Services
Estimate Number : 36928
P.O. Number : 11592
This Issue : 1/23/2008 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : SMALL /MED FAB
Previous Run : 31828
Written By :
Checked & Approved By : 08 01 23
Comment : Est B 02.11.12 Re-format; Incorporated D2911 and D2912 K
J
Est Rev:C Now on Waterjet 07-01-23 JLM

Drawing Name : DDOUBLER
Part Number : D2911
Drawing Number : D2911 REV A
Project Number : N/A
Drawing Revision : A
Material :
Due Date : 1/30/2008 Qty: 40 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S090 6061-T6 .090 Sheet



Comment: Qty.: 0.1219 sf(s)/Unit Total : 4.8762 sf(s)

6061-T6 .090 Sheet

Material: Sheet 6061-T6 x 0.090" thick

(M6061T6S.090)

Batch: 19059 19059 B 8-1-28

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2911

Dwg Rev: A B 8-1-28

Prog Rev: A

2-Deburr if necessary B 8-1-28

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



B 8-1-28



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

08/4/28 (154) coates

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 08/02/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/23/2008 11:39:00 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DDOUBLER

Job Number: 36928

Part Number: D2911

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form on CNC brake as per Dwg D2910, D2911, D2912 and QSI 034 4.1

SS 08/01/21 (54)

6.0

CHEMICAL TREAT

CHEMICAL TREATMENT



Comment: CHEMICAL TREATMENT

M-L 08/02/07

(54X)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counts
08/02/07 (54)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST53

AS 08/02/07 (54)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(54)
08/02/08

Job Completion



min 2008/2/07
(54)
V

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

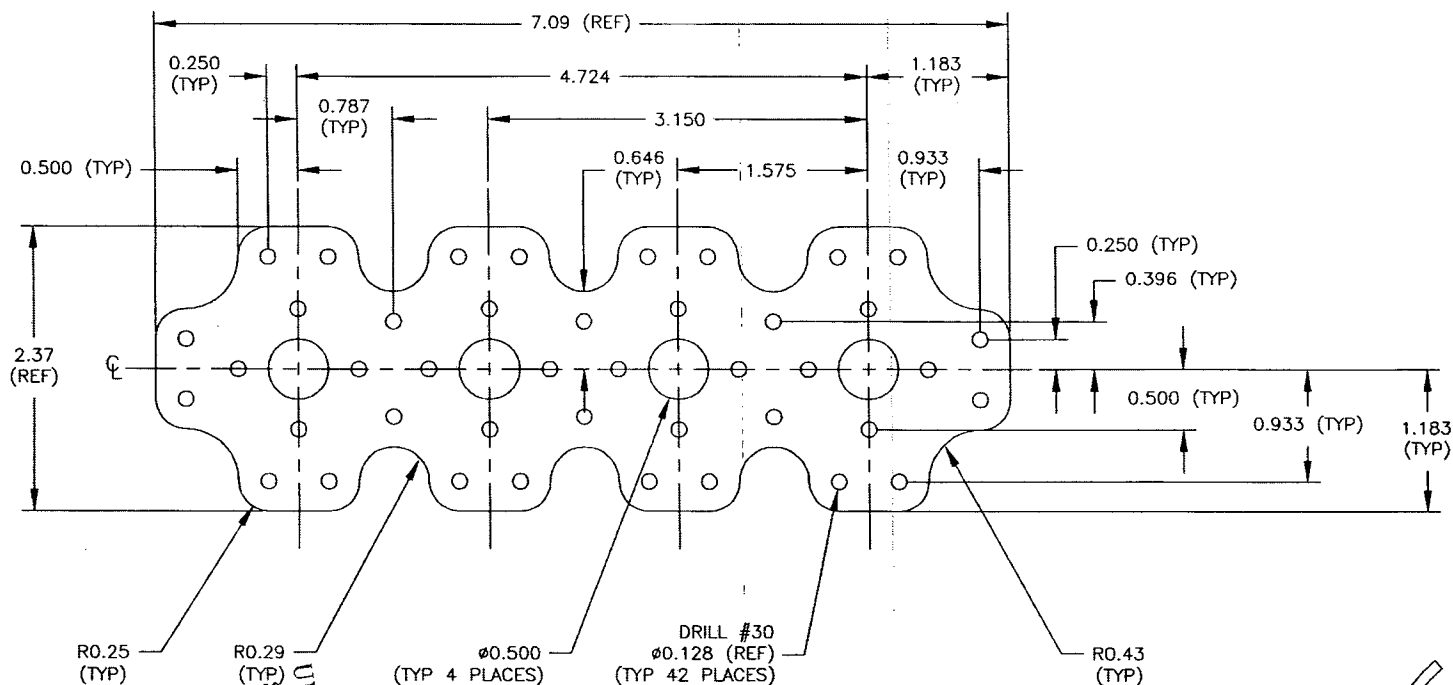
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
49.09.28 DS



R0.25
(TYP)

R0.29
(TYP)

(TYP 4 PLACES)

DRILL #30
Ø0.128 (REF)
(TYP 42 PLACES)

R0.43
(TYP)

NO. 36928
WORK ORDER
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

FLAT PATTERN

BENDING DETAIL

R1.51

MATERIAL: 6061-T6 SHEET (QQ-A-250/11) 0.091" THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

A	99.09.08	NEW ISSUE
DESIGN	CP	DRAWN BY RF
CHECKED	CP	APPROVED
DATE	99.09.08	TITLE
		DOUBLER
		DART AEROSPACE USA, INC.
		D2911
		REV. A
		SHEET 1 OF 1
		SCALE
		1:1